

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2015-119 Date Opened: 26-Oct-15 Title: Assembly

Aircraft OEM: Eurocopter Aircraft Model: AS350 Product Type: Cargo Basket Product Model: Ski w/ cut out Quantity: 1

Work Order Contents

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
JR
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JR
JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
76610	0	Basket	JR
76611	0	Body	JR
60632	0	Lid	JR
76625	0	Placard	JR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JR
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JR
N/A
N/A

Traveller

Install walkway on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

JR
JR
JR
JR
JR
JR
JR

Work performed by:

Print: J Rekve for M Rekve

Sign: Jason Rekve

SCA: AD01

Date: 30-Oct-15

ICC / Dual Inspection performed by:

Print: Jason Rekve

Sign: Jason Rekve

SCA: AD01

Date: 30-Oct-15

Work Order closed by:

Print: Jason Rekve

Sign: Jason Rekve

SCA: AD01

Date: 30-Oct-15

Approved Manufacturing Facility 73-04

Form 20.B.031

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2015-119	
6. Item	7. Description Cargo Basket	8. Part Number 94010-01	9. Qty. 1	10. Serial/Batch No. 94001-53	11. Status/Work New	
12. Remarks Modified with walkway on lid and RH front end cutout IAW DCL704						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.						
13b. Signature <i>Jeff Clarke AD02</i>		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 30 Oct 2015		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

Self Kirk Mountain

Description: Beam Pin

[illegible]



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

Aluminum Checker plate

Aircraft:

All

Model: All

Description:

5 7/8" x 10', .065", pattern c102

Supplier:

Daigle Marine

Color:

N/A

WO#:

N/A

PO# 15056



WO#

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2015-119

Date Open: 26 Oct 15

Apo

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

Apo

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ?? 17 ft lbs

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ?? *40 inch LB*
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation A006

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

AD06

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

AN06

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

OK

6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

CARGO BASKET HANDLE FABRICATION

General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2015-119

Complete
(initial or SCA #)

Date Open: 26 Oct 15

AD-05

1. Weld Lever Assembly – handle lever jig required
 - a. Set MS20615-4M3 monel rivet into socket in jig
 - b. Set 36274-01 bushing into socket in jig
 - c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
 - d. TIG weld around bushing using ER308L rod.
 - e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
 - f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
 - g. Record material POs on attached material list.

2. Clean up
 - a. Clean lever assembly by media blasting with glass bead.
 - b. Drill out lever bushing to O (0.316) on lathe:
 - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
 - ii. Run at 300 RPM.
 - iii. Apply a drop of Rapid-Tap to drill.
 - c. De-burr.

3. Fabricate Handle Assembly
 - a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
 - b. Measure across TOP side of levers.
 - c. Cut handle tubing to length measured.
 - i. Handles under 40" long: 1.0" x 0.035 round tube
 - ii. Handles over 40" long: 1.0" x 0.065 round tube
 - d. De-burr tube.
 - e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
 - f. Record material PO on attached material list.

ADOC

4. Weld Handle Assembly
 - a. Fuse tube to lever on both ends. Ensure levers are parallel.

AD-05

5. Clean up
 - a. Clean welded area with scotch-brite.

ADOC

6. Final Inspection –

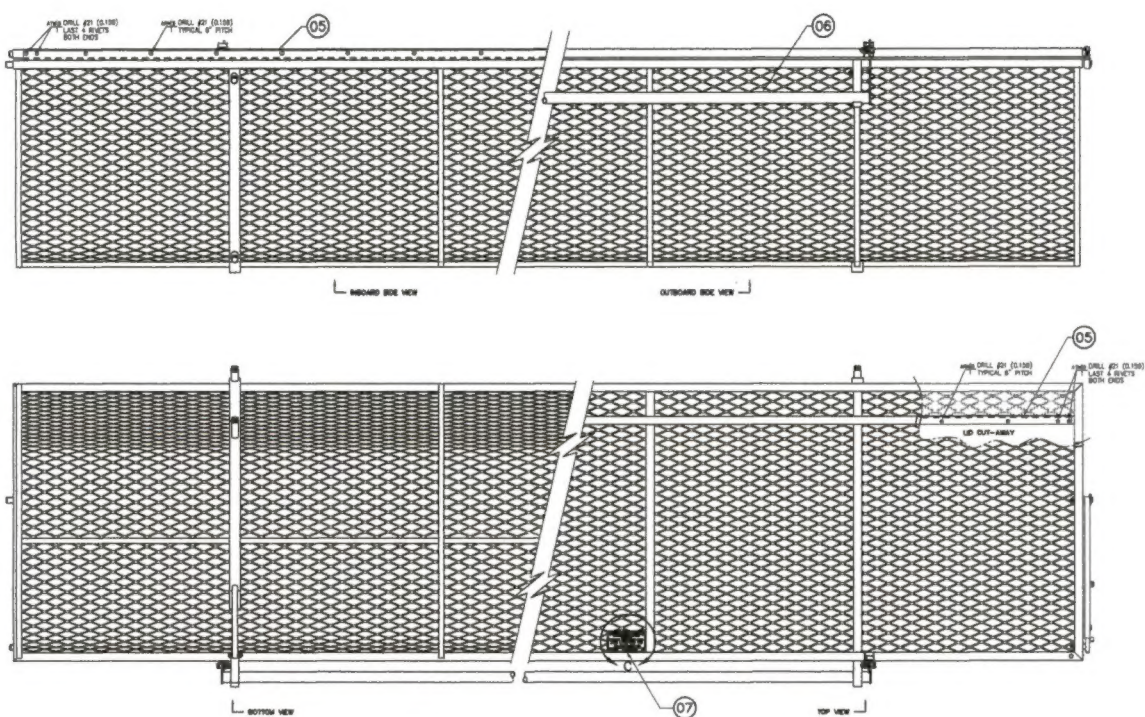
To be completed by a different person than the previous steps.

 - a. Welds for complete and handle for fit.
 - b. Tag complete and inspected parts in preparation for installation.

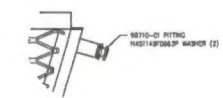
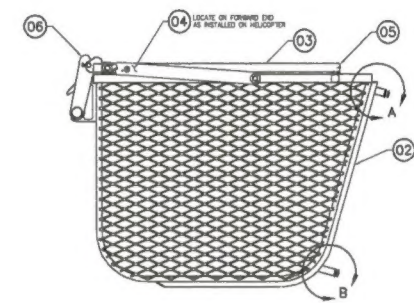
OK

2015-119

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK, ADD ALTERNATE FITTING HARDWARE FOR UPDATES		14/07/2014
2	CHANGE BRACE ASSEMBLY TO INSTALLATION		

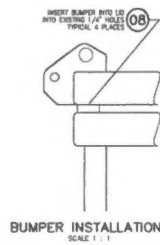


84010-01 CARGO BASKET ASSEMBLY - RH

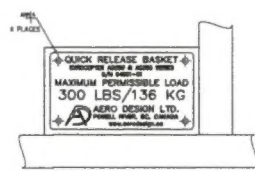


DETAIL A
SCALE 1 : 2
TYPICAL FRONT AND REAR

DETAIL B
SCALE 1 : 2
TYPICAL FRONT AND REAR



BUMPER INSTALLATION
SCALE 1 : 1



DETAIL C
SCALE 1 : 1
LOOKING AT PLACEHOLDER

NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STOPS.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SPEC
1	84010-01	ITEM	CARGO BASKET ASSEMBLY			

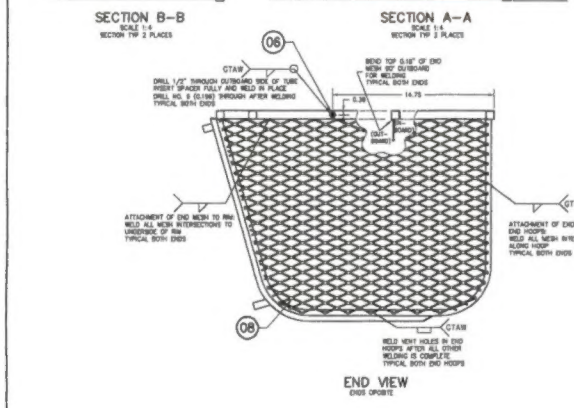
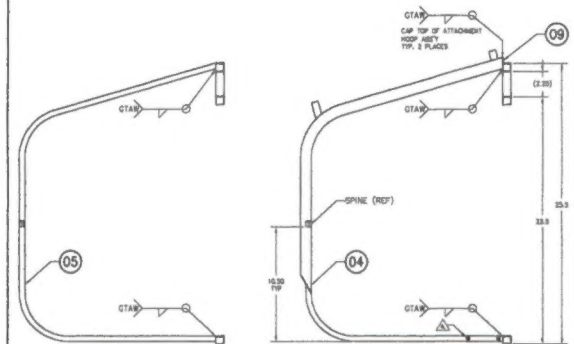
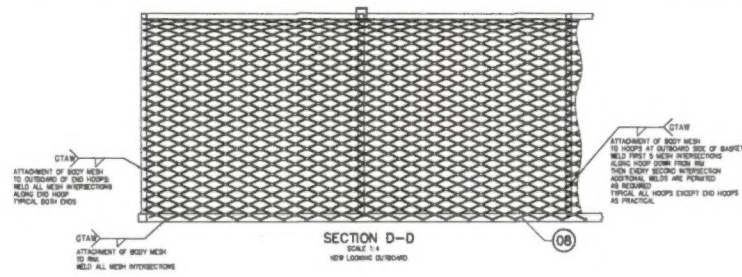
BASIC CODE	REF. DES. 522	QTY	DATE	APPROVALS	DATE
01	84010-01	1	20 OCT 2011	R. RATHNELL	20 OCT 2011
02	84010-01	1		E. BURTON	

AERO DESIGN LTD.
8888 KALASPIRA ROAD
PORTER, ALBERTA, CANADA T8A 5G3
TEL: 804.688.0878
WWW.AERODESIGN.CO

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
BASKET ASSEMBLY (EXTRA LARGE)

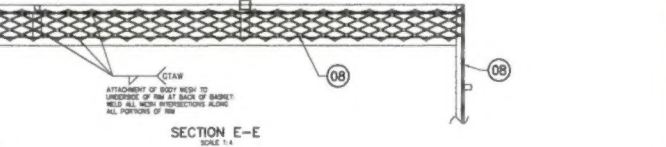
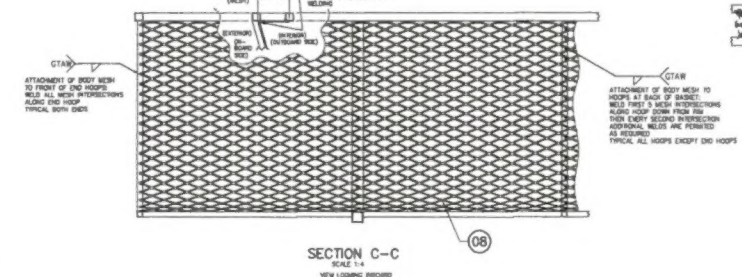
SCALE 1 : 2
SHEET 1 OF 1
AO 94010 1

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INITIAL ISSUE		
2	TITLE BLOCK UPDATED: WELDING RODS UPDATED: REFERENCE DRAWS ADDED: BUC		11/2017/2024
3	TITAN TUBING UPDATED: WELDS DOWN BODY BROWCASTED		



- NOTES:
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
 - PROVIDE TO WELDING, DRILL AND (ELIMINATE) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
 - WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AVOID SPALLS.
 - 4130 AND 1018 STEEL WELDING ROD SHALL CONFORM TO AWS A5.28 OR EQUIVALENT.
 - STAINLESS AND 4130 STEEL WELDING ROD SHALL CONFORM TO ENORM OR EQUIVALENT.
 - INSTALL (TYP) (DASHED) HANDLE PROTRUSION ASSEMBLY IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84205 BEFORE WELDING HOOPS TO RAIL.
 - FINISH THOROUGHLY CLEAN AND POWDER COAT BASKET ASSEMBLY.

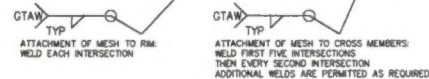
REV	DESCRIPTION	MATERIAL	QTY	DESCRIPTION	MATERIAL	QTY
1	3/4" TOP OF MESH	MILD STEEL	400	1018/4130	4130 BASKET	
2	WELDS	MILD STEEL	CONSUMABLE			
3	WELDS	MILD STEEL	CONSUMABLE			
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99	WELDS	MILD STEEL	CONSUMABLE			
100	WELDS	MILD STEEL	CONSUMABLE			



01 BASKET BODY ASSEMBLY

APPROVALS	DATE	REVISION	DATE
DESIGNED BY: R. BATHWELL	20 AUG 11	REVISED BY: A. KALLAPURAM	20 AUG 11
CHECKED BY: C. BURTON		REVISED BY: A. KALLAPURAM	20 AUG 11
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:		EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET BASKET BODY ASSEMBLY (EXTRA LARGE)	
DECIMALS	ANGLES	SCALE 1:1	REV
0.001 ±0.010	0.1° ±1/2°	1	1
0.01 ±0.03			
0.1 ±0.1			
SHEET 1 OF 1		AC 94011	



REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED: CHANGED 36273-01 TO 84263-01; ITEM #'S ADDED WELDING ROD UPDATED: # OF WELDS DOWN BRACE TUBES INCREASED	BJC	10/07/2014



END VIEW

TOP VIEW

① LID ASSEMBLY

- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2686S.
 3. 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO E70TS-2 OR EQUIVALENT.
 4. 4130 AND 1018 TABLETS: WELDING SHALL CONFORM TO CR-308, OR EQUIVALENT.
-  INSTALL ITEM 9 (LID HANDLE PROMOSIONS) ASSEMBLY IN ACCORDANCE WITH AERO DESIGN LID. DRAWING 04263.
-  DRILL #30 (0.125) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO WELD GASSES.
- BRACE ASSEMBLY IS COMPLETE. FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
5. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY.

1	36204-10	06	PLUARD BRACKET			
	84263-01	05	LID HANDLE PROVISIONS ASSEMBLY			
2	49216-01	04	SPACER			
A/R	3/4 - 16F	03	MESH	MILD STEEL	COMMERCIAL	
A/R		02	SQUARE TUBE	4130 STEEL COND. N	MIL-T-8736	0.75 X 0.035 SQR TUBE
	94012-01	01	LID ASSEMBLY			
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

APPROVALS		DATE		 AERO DESIGN LTD. 6886A MALAYSIA ROAD POWELL RIVER, BC, CANADA, V6A 0G3 TEL. (604) 481-2222 www.aerodesign.ca
DRAWN: R. RATHWELL		05 AUG 11		
CHECKED: E. BURGIN				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET LID ASSEMBLY (EXTRA LARGE)
DECIMALS		ANGLES		
X .XXX ±0.010		±1/2°		
X .XX ±0.03				
X .X ±0.1				
		SCALE: 1 = 4		
SHEET 1 OF 1		DWG. SIZE: A1		DWG. NO.: 94012
				REV.: 1

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	10/07/2014

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH
"S/N 94001-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"300 LBS/136 KG" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"POWELL RIVER, BC, CANADA" - 0.080 HIGH
"www.aerodesign.ca" - 0.080 HIGH


DRILL #30 (0.129)
4 PLACES



01 PLACARD

94027-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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	DRAWN: R. RATHWELL	OCT 3, 2011				
	CHECKED: E. BURGAIN					
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET PLACARD			
	SCALE 1 : 1 SHEET 1 OF 1		DWG. SIZE A4	DWG. NO. 94027	REV. 1	